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SPLIT

DART AEROSPACE LTD	Work Order:	20957A
Description: Bearpaw Kit (19" x 16")	Part Number:	K10007
Dwg: D2435 Rev. E1; DSK086-3 Rev. A	Qty:	20
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required	HA	04.06.01	20
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately)	HA DH	04.06.29 04.07.07	10 10 20
3	GA	Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 19.50" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) Batch: M14864 M15675	HA	04/06/30	20
4	MV	Inspect material for defects or damage prior to machining	HA	04/06/30	20
5	MV	Machine as per Folio D2435 and Dwg D2435 Identify as D2435	HA	04/06/30	20
6	QC2	Inspect parts as they come of the CNC machine	HA	04/06/30	20
7	MV	Deburr	HA	04/06/30	20
8	QC8 & 5	Second inspection	HA	04-07-08	20
9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) Qty Part Number Description Batch 4 ✓ D2182B050 ✓ Rubber Cushion B20434 8 ✓ D2274 ✓ Radius Block B20655 2 ✓ D2435 ✓ Bearpaw B20957 4 ✓ D2438 ✓ Clamp B20387 8 ✓ D2529 ✓ Washer B20388 8 ✓ AN4-15A ✓ Bolt M14544 8 ✓ AN4-17A ✓ Bolt M14311 16 ✓ AN960JD416 ✓ Washer M14855 8 ✓ MS21042L4 ✓ Nut (or -4) M14478 2 ✓ QS200M44S ✓ Clamp M13928/M14913/M15106 1 Paperwork package from Step 2	HA	04/07/08	19
10	QC4	Inspect Kit for 100% Completeness on the W/O	HA	04/07/08	19
11	PK	Identify and pack for shipping as per PPP K10007 Rev. D	HA	04/07/09	19
12	AC	Cost / part 147.85	HA	04-07-13	19
13	DC	Close W/O 197.37 Inspect Level 21	HA	04.07.12	19

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	
E	04.02.17	Blank size changed, tolerance added to Step 3	KJ/JLM	

RELEASED
04-02-20

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20957
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

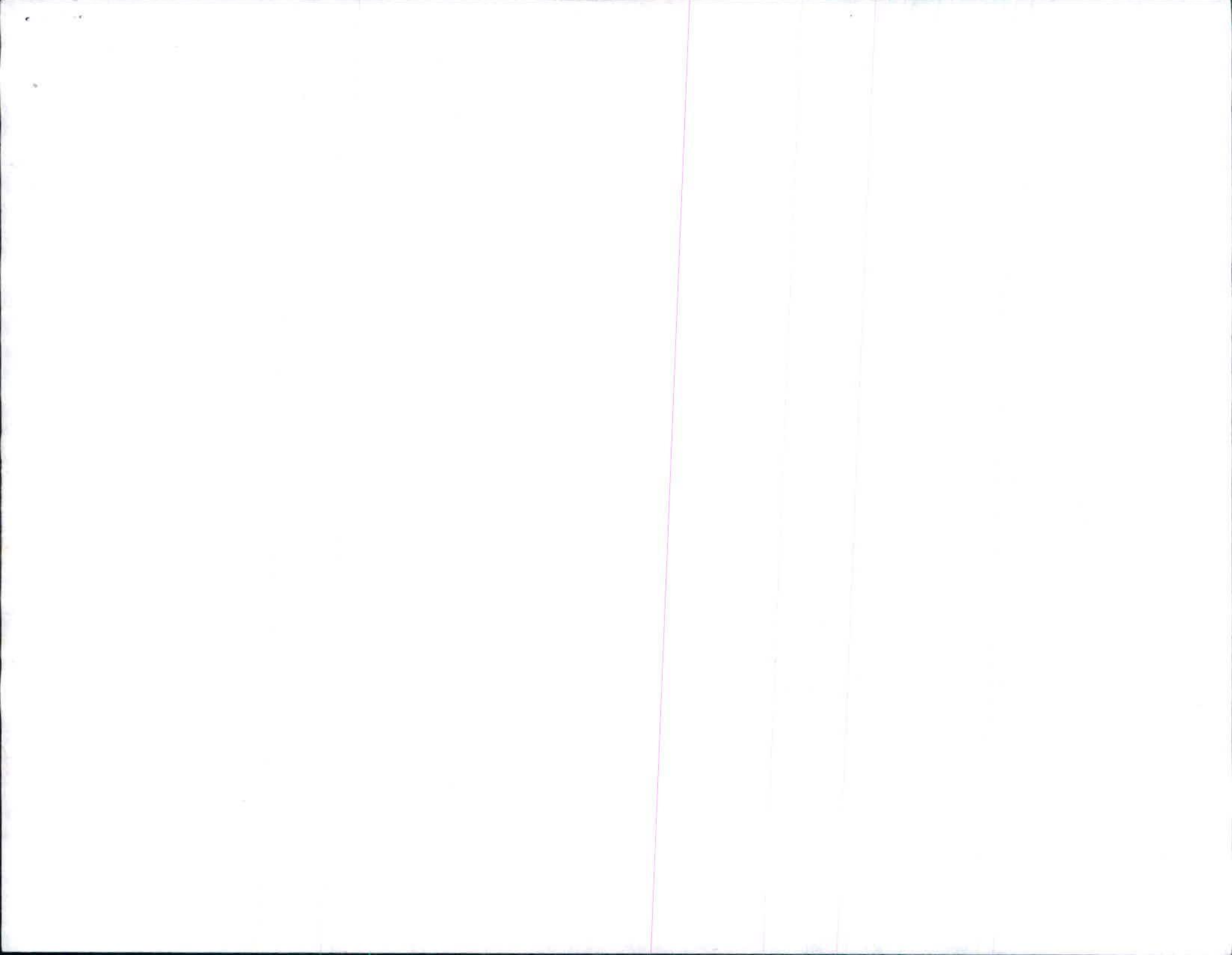
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.068x45°	✓		Vern	
B	5.500	+/-0.030	5.503	✓		Vern	
C	0.200	+/-0.030	0.200	✓		Vern	
D	R0.250	+/-0.030	R0.250	✓		R-G	
E	0.250	+/-0.010	0.245	✓		Micr	
F	0.625	+/-0.030	0.633	✓		Vern	
G	0.25 x 45°	+/-0.030	0.225x45°	✓		Vern	
H	0.375	+/-0.010	0.367	✓		Vern	
I	19.000	+/-0.030	19.025	✓		M-Tape	
J	0.950	+0.030/-0.010	0.960	✓		Vern	
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
L	Ø0.930	+/-0.030	Ø0.925	✓		Vern	
M	0.30	+0.030/-0.000	0.320	✓		Vern	
N	0.375	+/-0.030	0.392	✓		Vern	
O	7.375	+/-0.030	7.375	✓		M-Tape	
P	4.250	+/-0.010	4.255	✓		Vern	
Q	2.000	+/-0.030	2.004	✓		Vern	
R	9.000	+/-0.010	9.000	✓		M-Tape	
S	15.750	+/-0.030	15.750	✓		M-Tape	

Measured by: <i>mf</i>	Audited by: <i>fe</i>	Prototype Approval:	N/A
Date: 04/06/30	Date: 04.06.30	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O K10007	KJ/RF

RELEASED

04.01.15



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 01, 2004
01:56 pm

Work Order No : 0020957
Project Name : *K10007
Project For : WK427
Work Order Type : Main
Main WO Number :
House Part Number : *K10007
Description : Bearpaw Kit 19" x 16"
Manufactured : Yes
Amount Req'd : 420 u
Amount Done : 0
Start Date : 06-01-04
Est Finish Date : 06-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00